

Date: Monday, 06/10/2008 1:20:28 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET	
Job Number	: 42468		Part Number	: D324513	
Estimate Number	: 13063		Drawing Number	: D3245 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 06/10/2008	S.O. No. :	Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: //	Type	: SMALL /MED FAB		
Previous Run	: 35666		Due Date	: 20/10/2008	Qty: 4 Um: Each
Written By	:				
Checked & Approved By	: <u>JUL 08.10.08</u>				
Comment	: Est B 04.12.06 Made in-house KJ/JLM Est Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D3245	Gasket
Comment: Qty.: 0.0485 sf(s)/Unit Total : 0.1940 sf(s) GASKET Batch: <u>35667</u> <u>FB 8-10-14</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3245 Dwg Rev: <u>B</u> <u>FB 8-10-14</u> (6)		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>FB 8-10-14</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SO 08/10/14</u> (6)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>79</u> <u>8/10/15</u> <u>SP</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 1:20:28 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 42468

Part Number: D324513

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/10/16 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42468
Description: Gasket	Part Number:	D3245-13
Inspection Dwg: D3245	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 8-10-14	Date: 8/10/14	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	JK

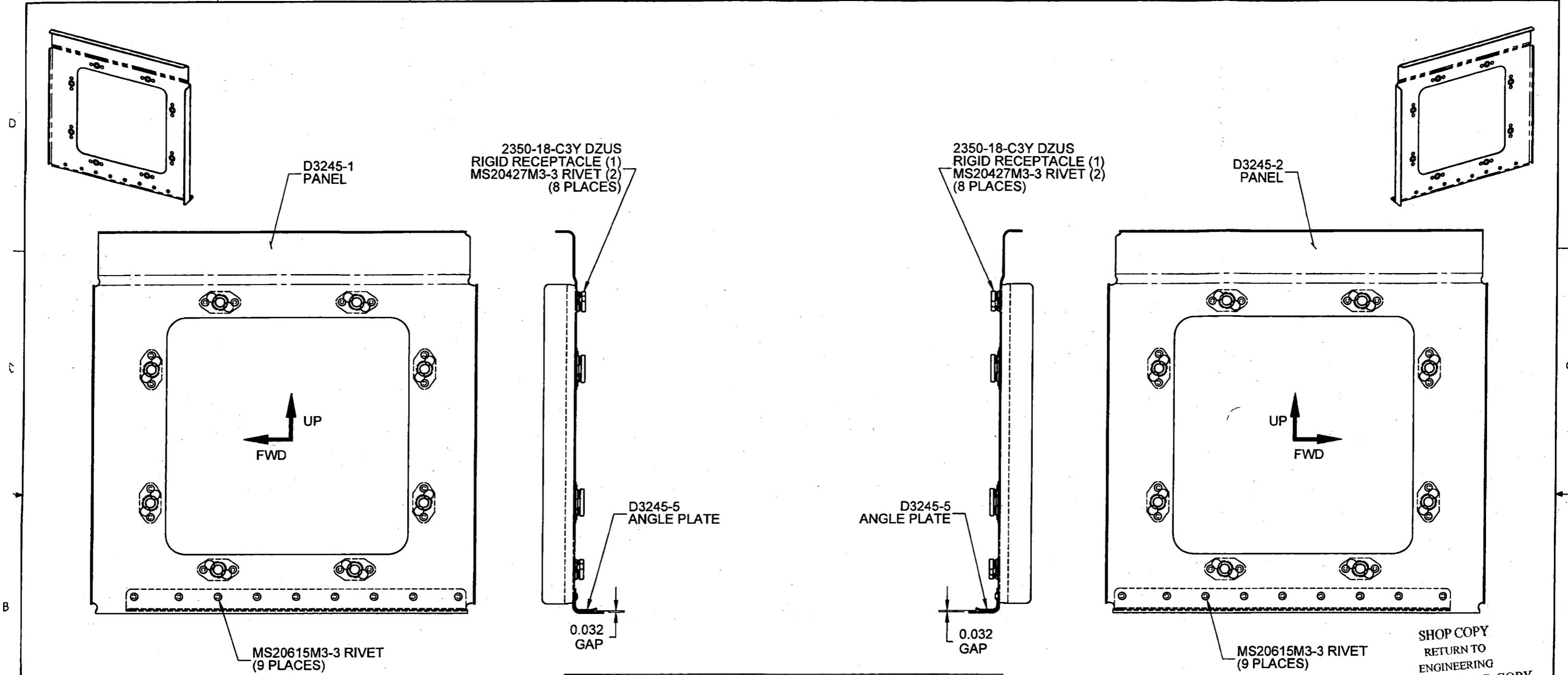
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
07.10.02

NOTES:

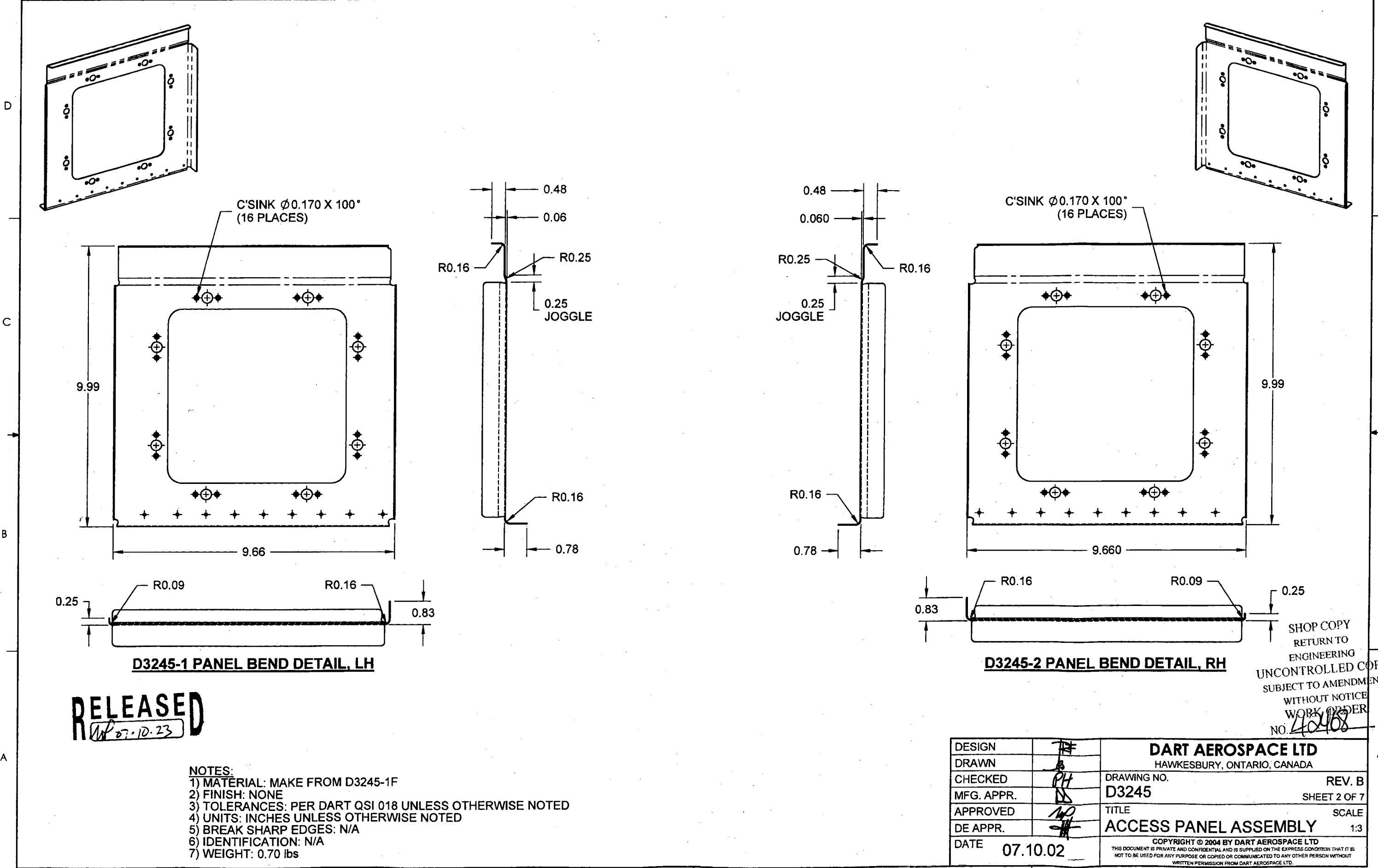
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
		D3245-042	ACCESS PANEL ASSEMBLY, RH
1	1	D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

D3245-042 ACCESS PANEL ASSEMBLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 110408

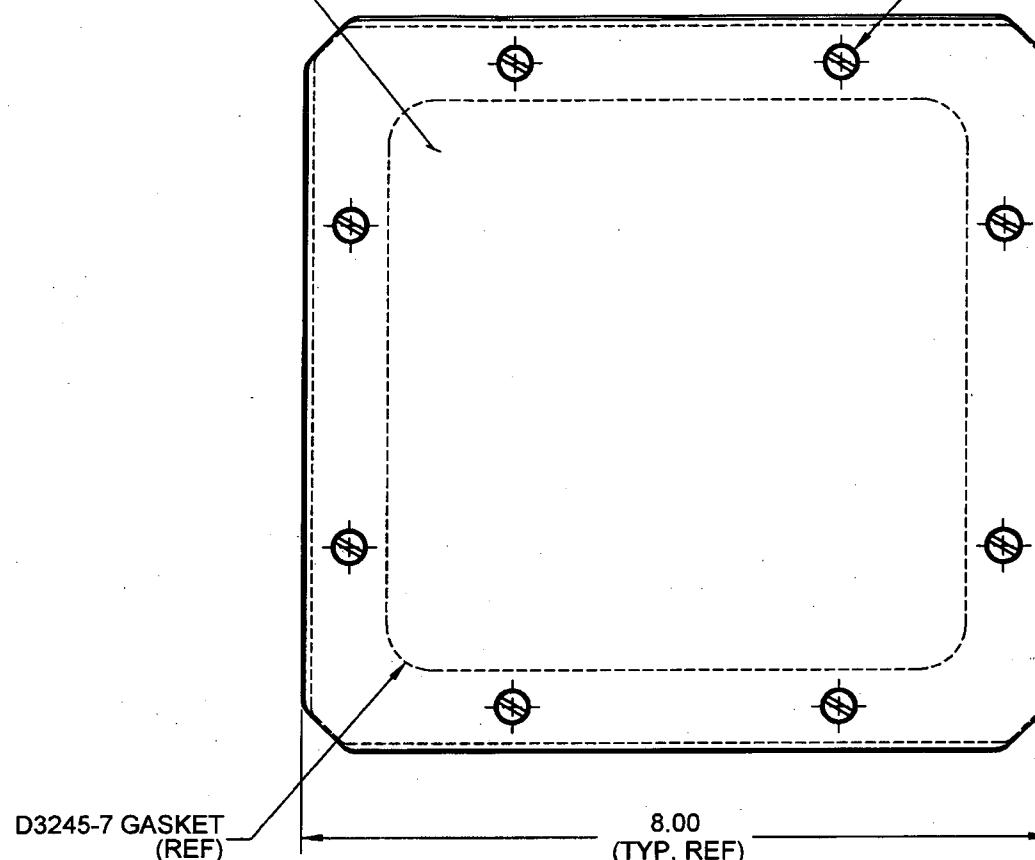
B	REMOVE Ø 0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042; HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	BB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DK	D3245	SHEET 1 OF 7
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	ACCESS PANEL ASSEMBLY	1:2.5
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8 7 6 5 4 3 2 1

D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)



D3245-7 GASKET
(REF)

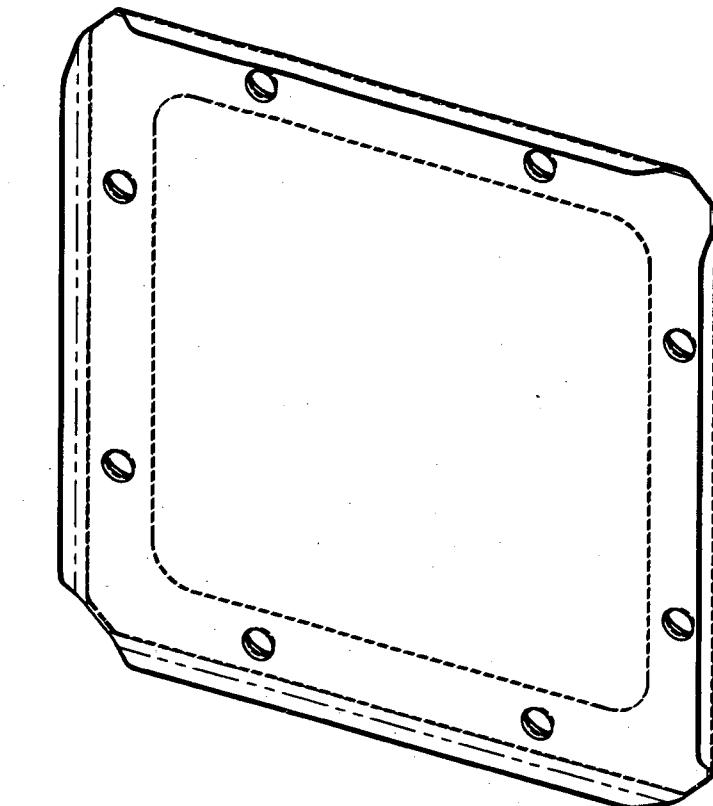
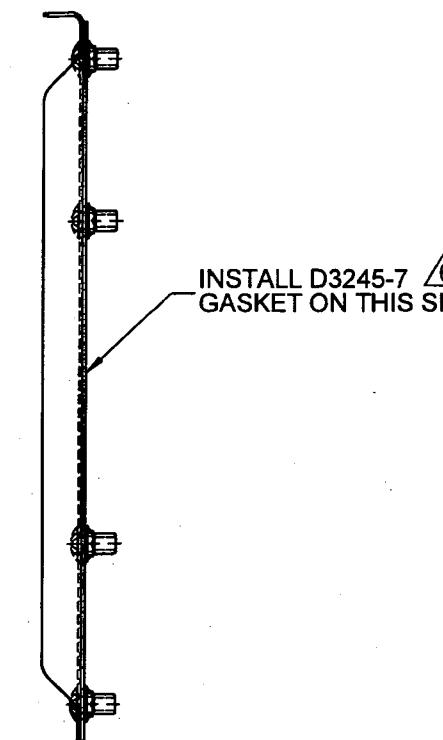
D3245-043 DOOR ASSEMBLY

QTY	P/N	DESCRIPTION
1	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

RELEASED
M 07.10.02

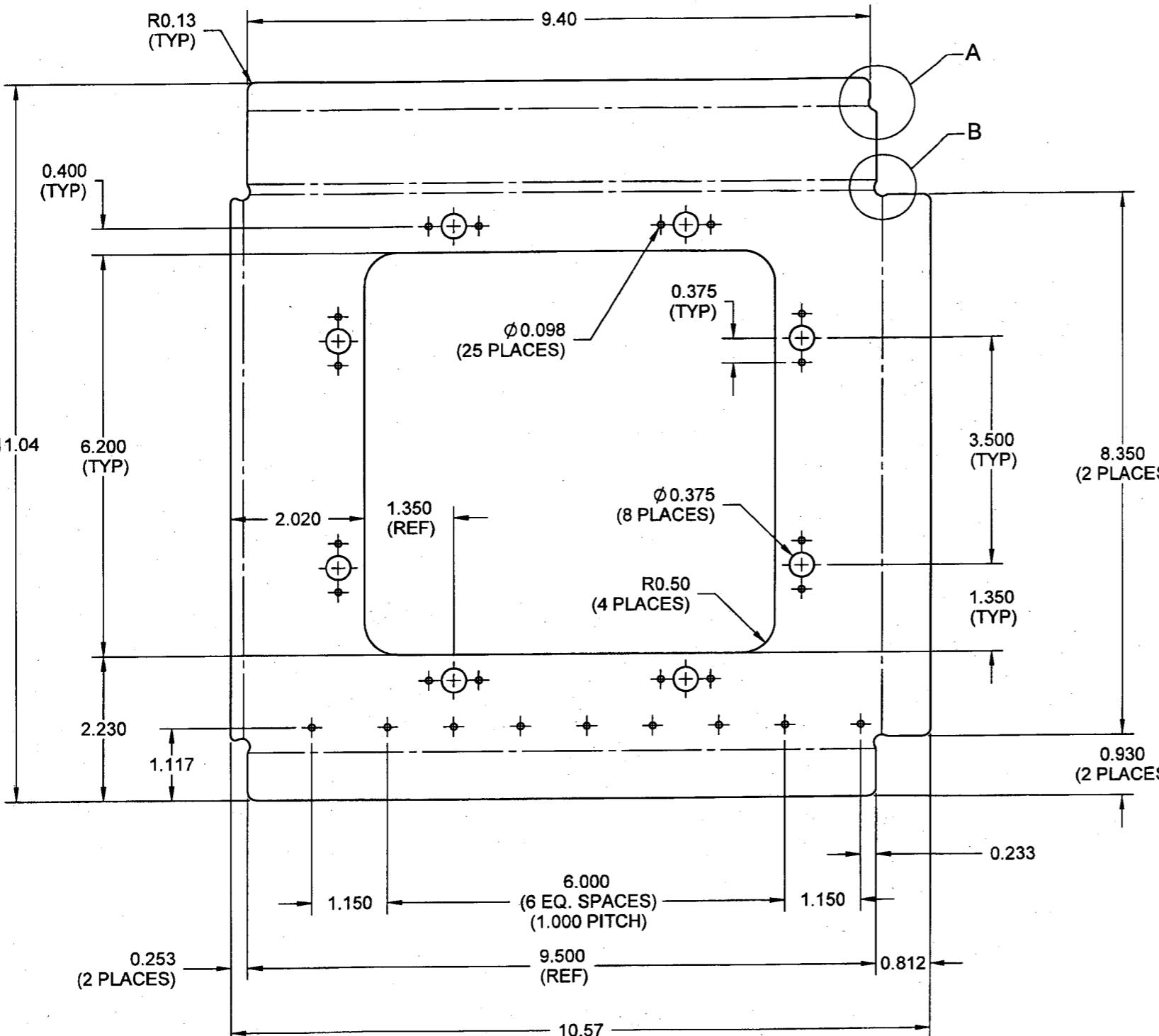
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs



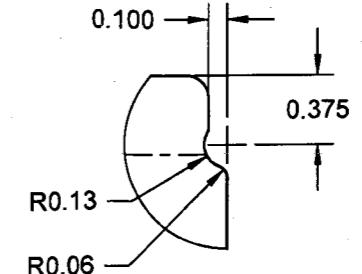
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WORK ORDER
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DESIGN	RF	DART AEROSPACE LTD
DRAWN	B	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	DS	REV. B
APPROVED	NO	SHEET 3 OF 7
DE APPR.	SH	TITLE
DATE	07.10.02	SCALE 1:2
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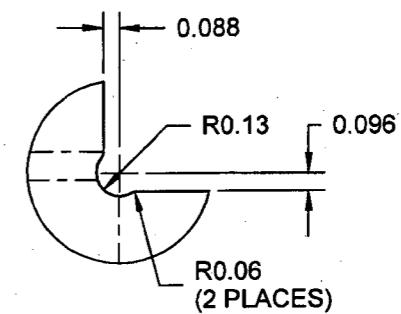


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10/10/02

D3245-1F PANEL FLAT PATTERN



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
(TYP, 4 PLACES)
SCALE 1:1

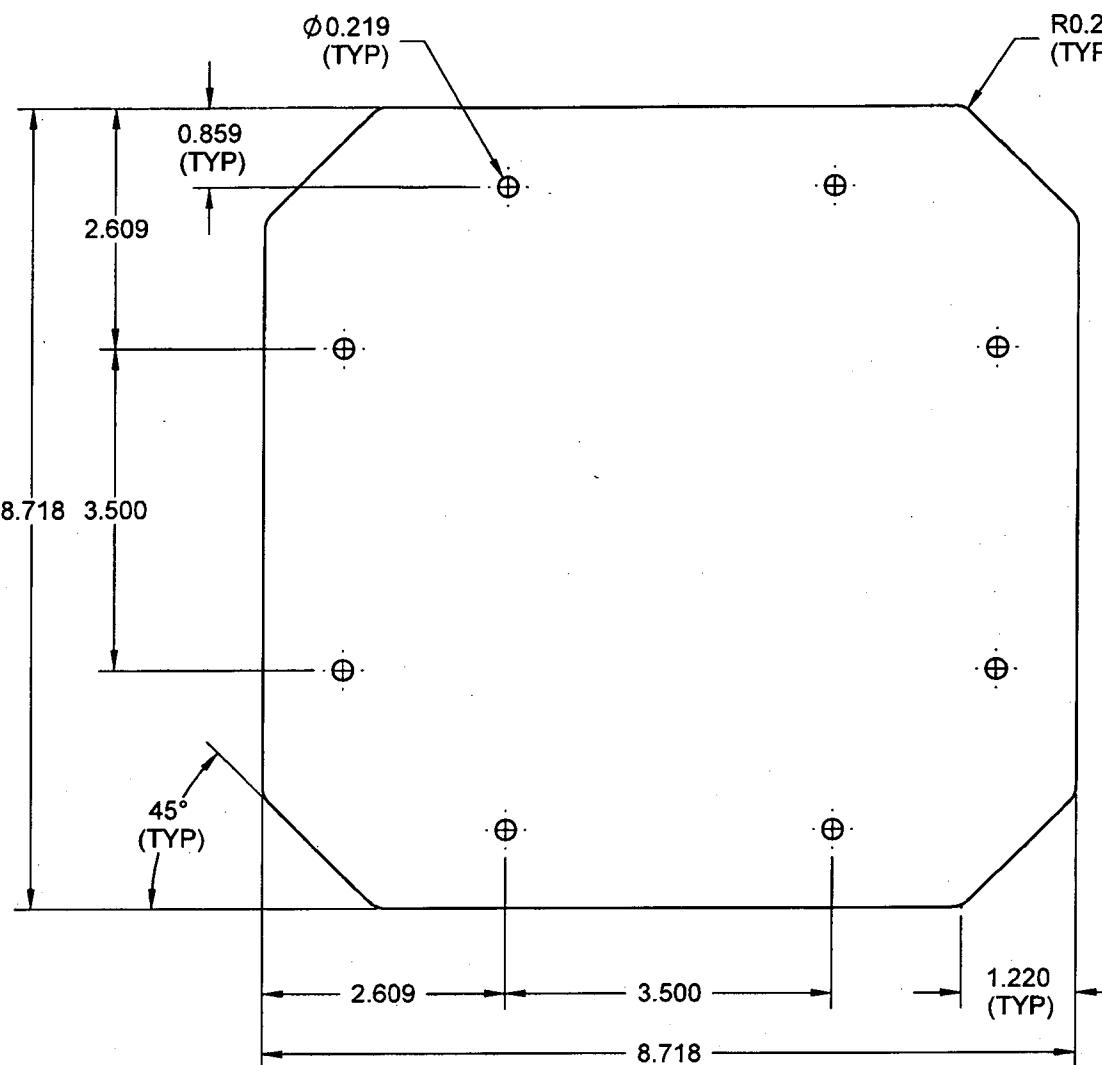
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WORK ORDER
NO. 42408

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<u>7</u>	DART AEROSPACE LTD
DRAWN	<u>8</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>PH</u>	DRAWING NO.
MFG. APPR.	<u>PS</u>	REV. B
APPROVED	<u>PS</u>	D3245
DE APPR.	<u>PS</u>	SHEET 4 OF 7
DATE	07.10.02	TITLE
		SCALE
		1:2
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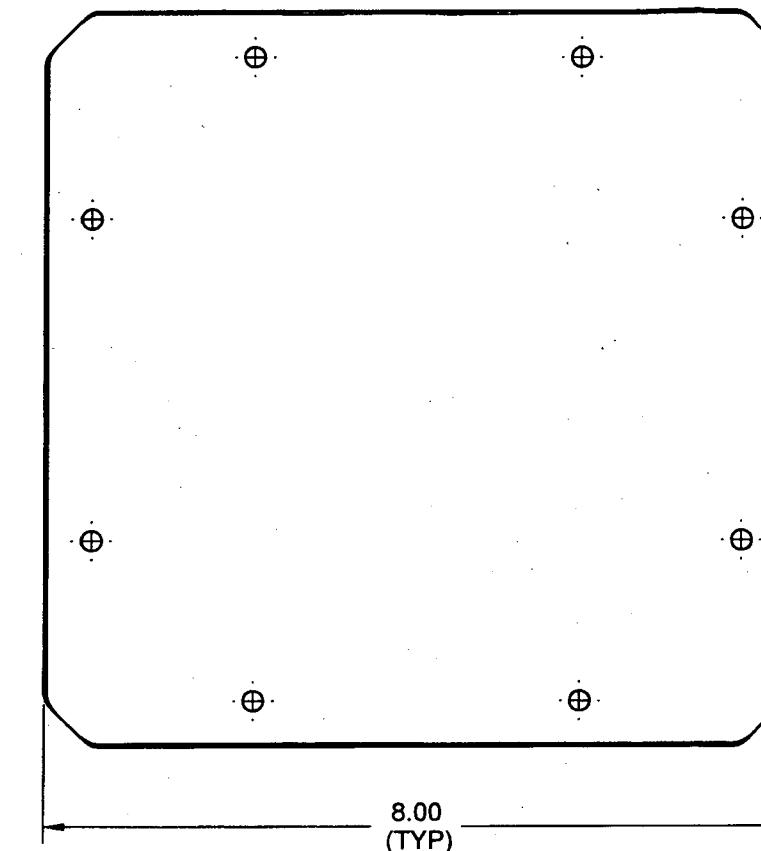


D3245-3F DOOR FLAT PATTERN

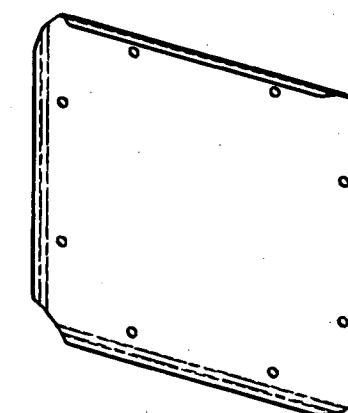
RELEASED
07.10.02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

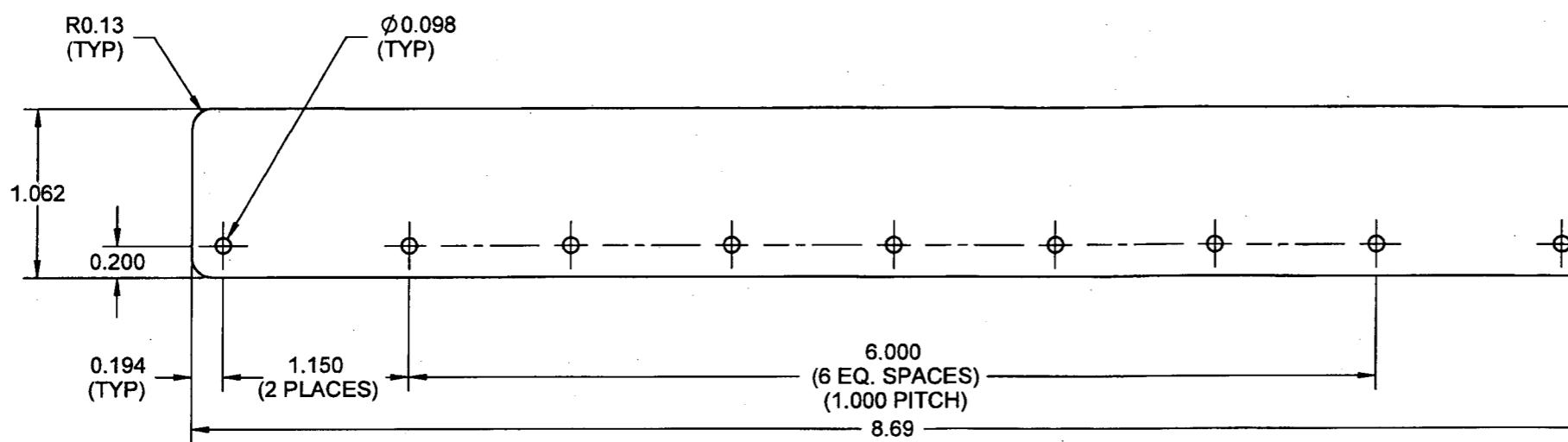
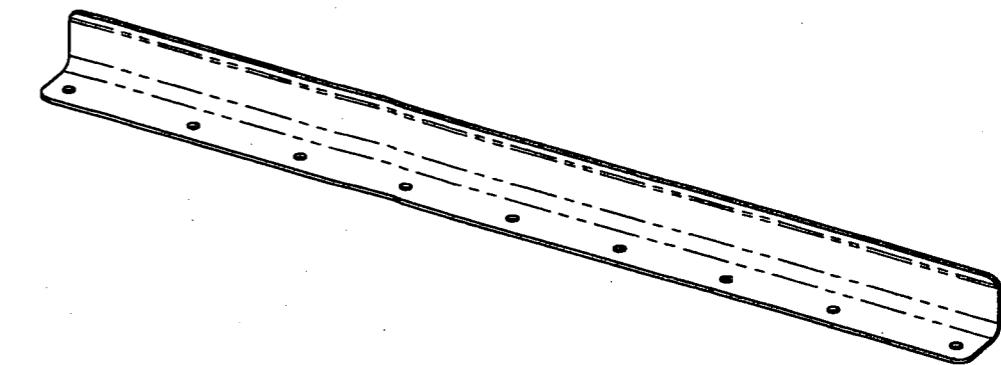


D3245-3 DOOR BENDING DETAIL

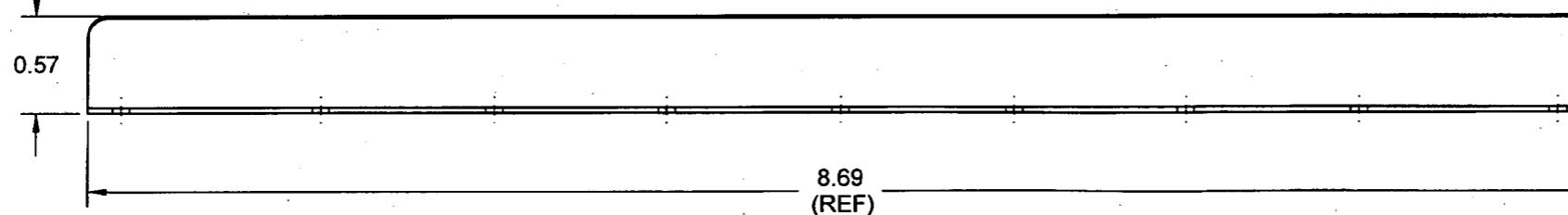


DESIGN	RF	DART AEROSPACE LTD			
DRAWN	b	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PH	DRAWING NO. D3245			
MFG. APPR.	DS	REV. B			
APPROVED	MP	SHEET 5 OF 7			
DE APPR.	MP	TITLE			
DATE	07.10.02	SCALE 1:2			
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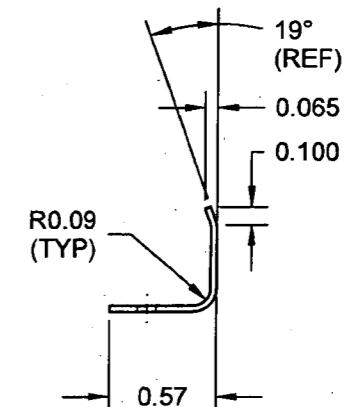
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D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)



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07.10.02

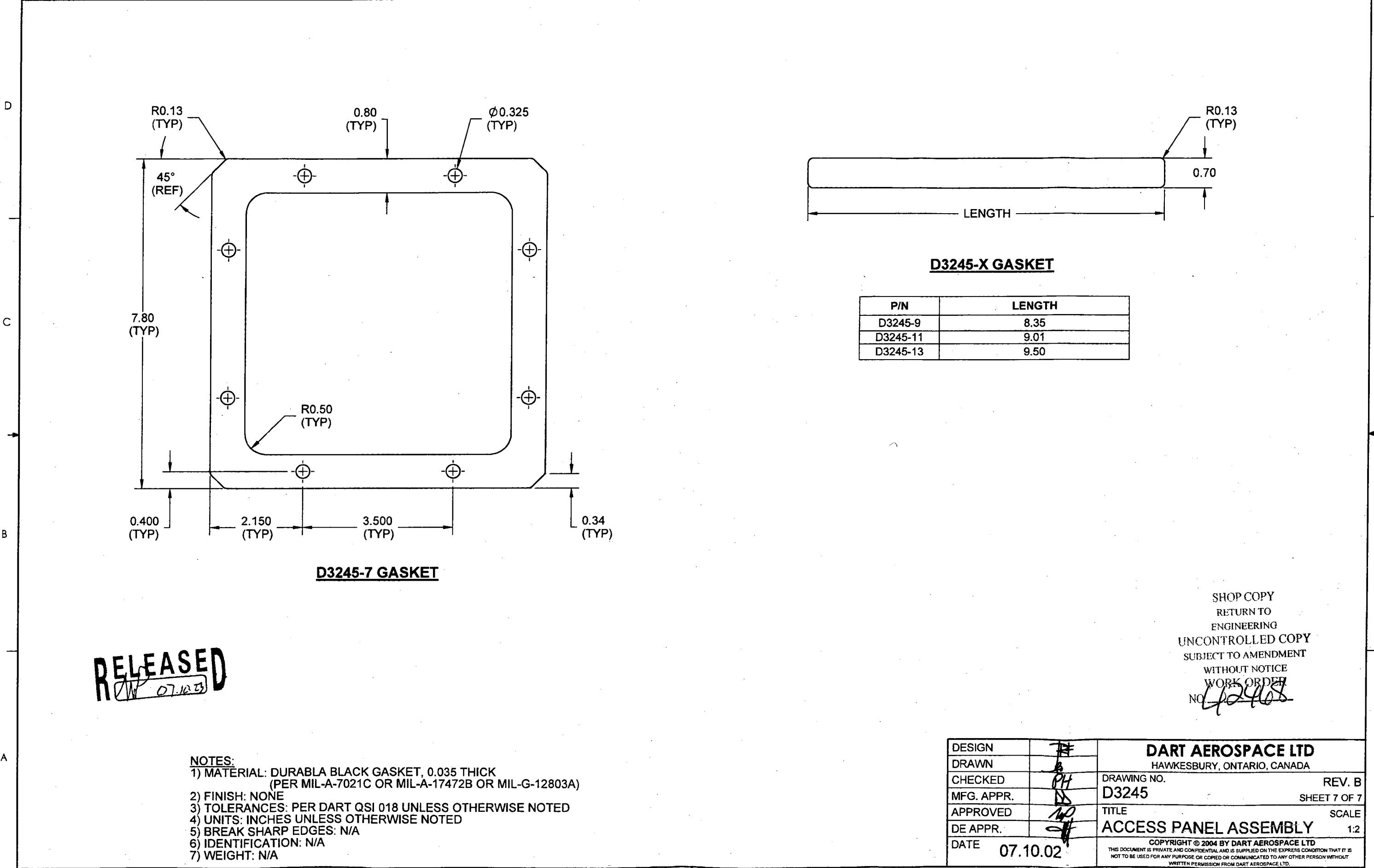
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WORK ORDER
NO 120408

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
 PER MIL-S-5019 (ANNEALED) 2B FINISH
 (REF. DART SPEC. M304S22GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.08 lbs

DESIGN	PF	DART AEROSPACE LTD
DRAWN	BS	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	NA	REV. B
APPROVED	100	SHEET 6 OF 7
DE APPR.	NA	TITLE
DATE	07.10.02	SCALE 1:1
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1